

TFW-309LMo

AWS A5.22 E309LMoT1-1
EN ISO 17633-A-T 23 12 2 L P C1 1

Characteristics and Applications:

TFW-309LMo is a modified type of TFW-309L with the addition of molybdenum. It is suitable for joining stainless steels to unalloyed steels. The addition of molybdenum enhances creep strength and improves corrosion resistance.

Notes on usage:

1. Before welding, oil, rusty, and moisture should be cleaned off the base material that should have the proper protection from the wind in welding site.
2. Use 99.8% or higher purity CO₂ as shielding gas.
3. Keep the product dry, while it is stored or delivered.

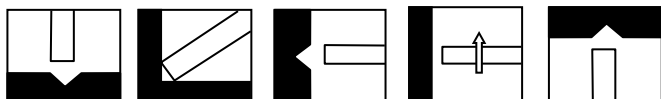
Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Cr	Ni	Mo
0.025	1.16	0.57	0.023	0.007	23.46	12.51	2.20

Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation %
685(99)	33

Welding position:



Sizes and recommended parameter range (DC +):

Stick out:15-20(mm),flow rate:20-25(l/min):

Position	Diameter (mm)	1.2
F, HF		130A-220A/24V-33V
H		140A-180A/25V-29V
V-UP		130A-160A/24V-28V
OH		150A-180A/25V-29V

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